

Work Order ID 111128

January-09-14 12:30:50 PM

111128

Rev E S 14/01/24
PRELIMINARY ISSUE

Page 1

Item ID: D4634-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Fwd, Center Ceiling Panel Assembly

Stop *NS2*

Start Date: 09/01/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 24/01/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

MP, MLC

Date: 14-01-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DAS

27

9-89

D4634

PD2 E

Rev E

REV E 14/01/09

100

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

①

SAD

14/01/23

110

110

Small Fab

Memo

0.00

Small Fab

1- Assemble as per Dwg D4634-041

2- install No Smoking & seat belt symbols

3- Install led lights

4- Install Air valves

5-Install Wiring Harness

5-Install wiring harness

①

SAD

14/01/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 111128

January-09-14 12:30:50 PM

111128

Page 2

Item ID: D4634-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd, Center Ceiling Panel Assembly
 Start Date: 09/01/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 24/01/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00	DAS						
120			27						
QC	Memo	0.00	9-89						
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE 1401-24

RELEASED 5 DATE 14/01/24

POSITIVE RECALL

EFFECTIVE 1401-24

RELEASED DATE

DAS
27
9-89

14/1/23

Release Dept
Rev E

MCJ 1401-24

14/01/24

Impact: G P
Rev PEJ

Thermo

MCJ

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

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Picklist Print

Thursday, January 23, 2014 8:15:23 AM

Page 1

Work Order ID: 111128

Parent Item: D4634-041

Parent Item Name: Fwd, Center Ceiling Panel Assembly

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
release DL VERIFIED BY:JLM IPP Rev B 12/11/08 Document
IPP Rev C 13/07/09 Dwg Update DL verf: DD
IPP Rev D Dwg Update 13/12/23 DL
IPP REV E Dwg update 14/01/20

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4743-1 Speaker Grill		Manufactured	No				Each	30.0000					
				<u>Location</u>		<u>Loc Qty</u>				<u>Loc Code</u>			
				ST122		30							
				111220		30							
MS21044-N08 Nut		Purchased	No				Each	265.0000					
				<u>Location</u>		<u>Loc Qty</u>				<u>Loc Code</u>			
				ST315		265							
				123741		115							
				m127813		150							
MS24693-BB50 SCREW		Purchased	No				Each	100.0000					
				<u>Location</u>		<u>Loc Qty</u>				<u>Loc Code</u>			
				ST300		100							
				m127924		100							
NAS1149DN832J Washer		Purchased	No				Each	3,136.0000					
				<u>Location</u>		<u>Loc Qty</u>				<u>Loc Code</u>			
				ST293		1000							
				M127813		1000							
				st510		376							
				124555		376							
				ST510a		1760							
				M126319		760							
				M127255		1000							

Picklist Print

Thursday, January 23, 2014 8:15:24 AM

Page 2

Work Order ID: 111128

Parent Item: D4634-041

Parent Item Name: Fwd, Center Ceiling Panel Assembly

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

D4634-141 Manufactured No
Fwd, Center Ceiling Replacement Panel Assembly

100 Each 2.0000

1

SAD 14/01/23

Location

Loc Qty

Loc Code

prelim

2

111145

1

111148

1

①

D4646-1 Manufactured No
Plenum Cap Assembly

100 Each 84.0000

2

SAD² 14/01/23

Location

Loc Qty

Loc Code

ST116

84

103832

66

92968

6

95779

12

2

D4652-1 Manufactured No
Air Valve, 1.16 Id Disk Type

100 Each 215.0000

2

SAD² 14/01/23

Location

Loc Qty

Loc Code

prelim

24

111316

12

111317

12

ST099

191

111311

191

2

D4728-047 Manufactured No
Advisory Light, Fwd

100 Each 0.0000

1

mini 93

SAD 1 14/01/23

D4728-051 Manufactured No
Cabin Lights #1

100 Each 1.0000

1

SAD 1 14/01/23

Location

Loc Qty

Loc Code

ST121

1

93456

1

mini 200

①

Thursday, January 23, 2014 8:15:24 AM

Shop Packet Print

Page 2

Picklist Print

Thursday, January 23, 2014 8:15:24 AM

Page 3

Work Order ID: 111128

Parent Item: D4634-041

Parent Item Name: Fwd, Center Ceiling Panel Assembly

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

PLT1.5M-M

Purchased

No

100

Each

1,008.0000

8

Tie Wrap

8 SAD 14/01/23

Location

Loc Qty

Loc Code

ST389

1008

124363

8

m126551

1000

50-009-2

Purchased

No

100

Each

1.0000

1

Grommet

1 SAD 14/01/23

Location

Loc Qty

Loc Code

ST378

1

122594

1

2351-20-27-C3C

Purchased

No

100

Each

80.0000

1

STUD

128022

1 SAD 14/01/23

Location

Loc Qty

Loc Code

ST396

80

m126740

30

m127922

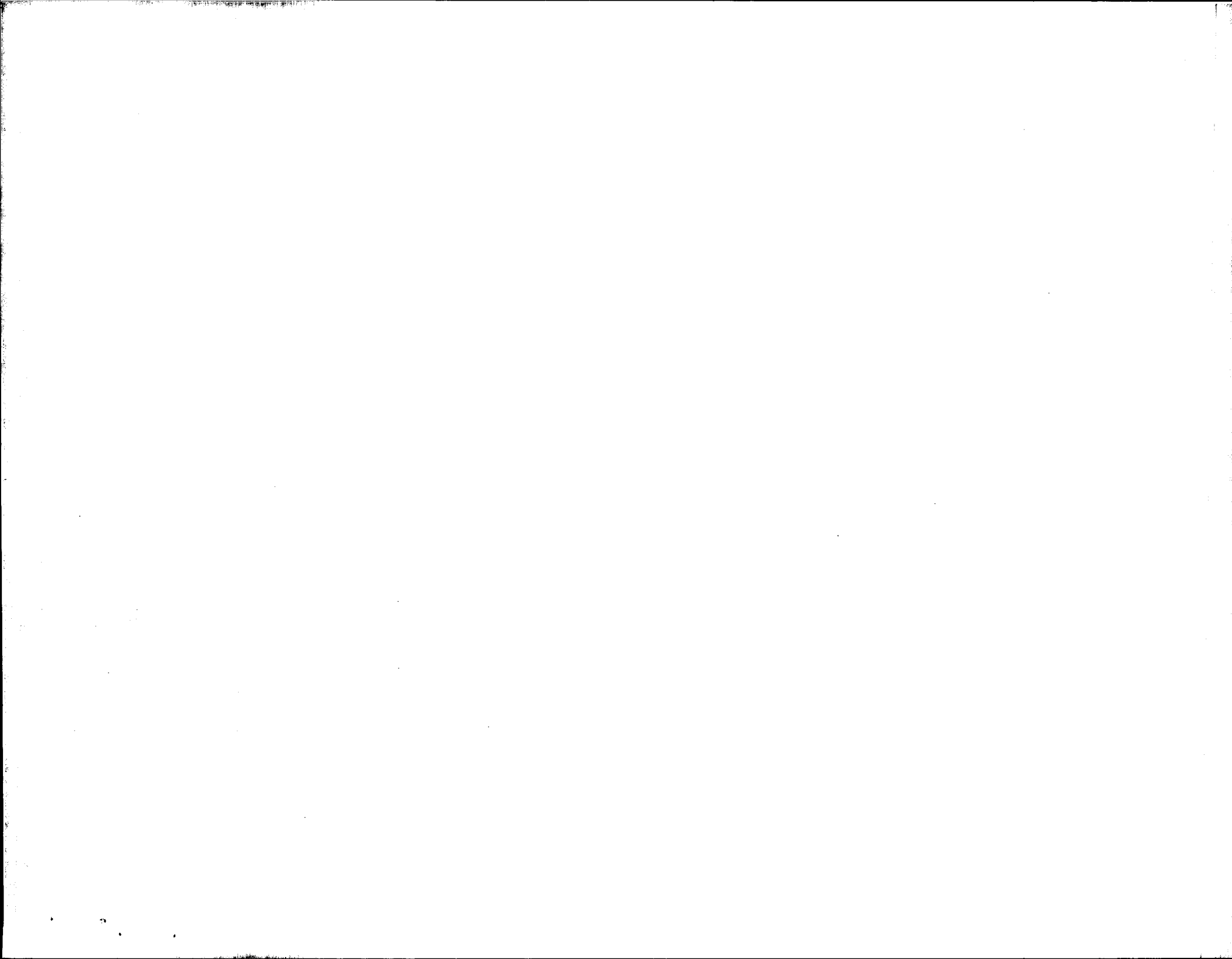
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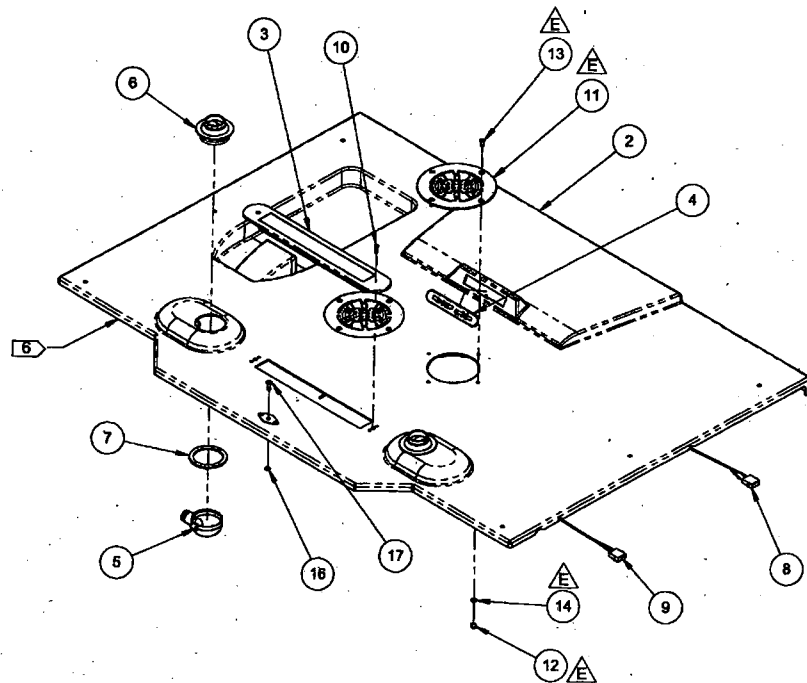
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Thursday, January 23, 2014 8:15:24 AM

Shop Packet Print

Page 3





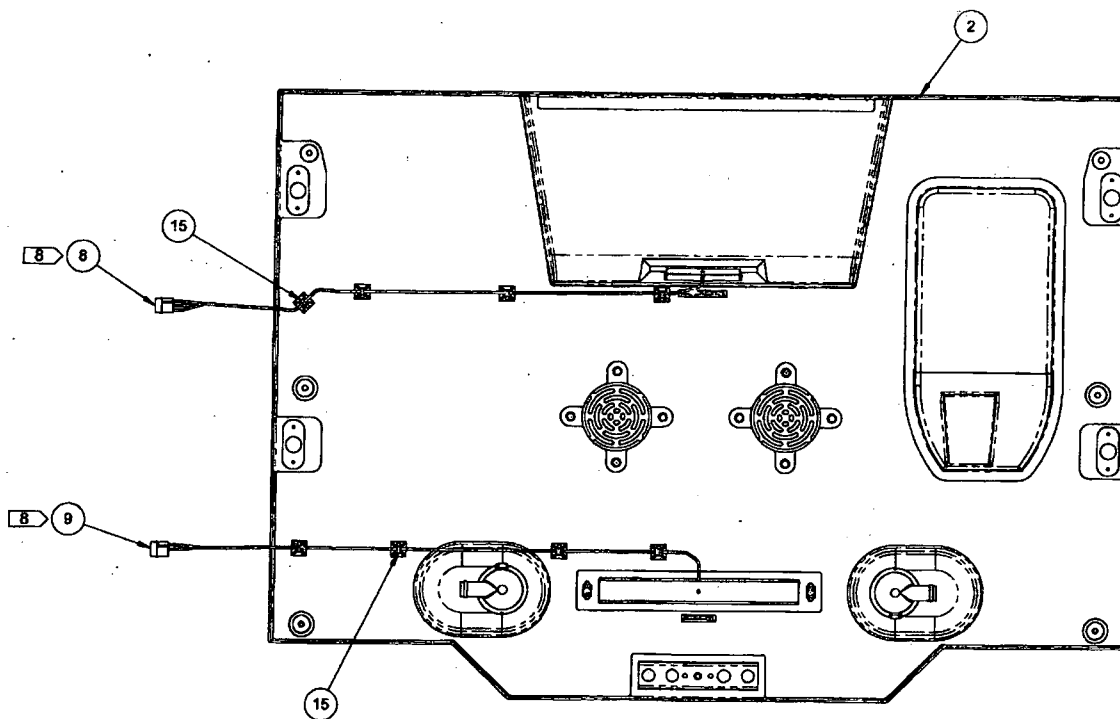
D4634-041 FWD, CENTER CEILING PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 7.0 lbs
- 8) INSTALL D4728-047/051 WIRE HARNESS PER QSI 048

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4634-041	FWD, CENTER CEILING PANEL ASSY
2	1	D4634-141	FWD, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4638-1 (REF)	LED LIGHT (REF PART OF D4728-051)
4	1	D4645-1 (REF)	NO SMOKING & FASTEN BELT LIGHT (PART OF D4728-047)
5	2	D4846-1	PLENUM CAP ASSEMBLY
6	2	D4852-1	AIR VALVE
7	2	D4852-3 (REF)	MOUNTING NUT (PART OF D4852-1)
8	1	D4728-047	ADVISORY LIGHT (FWD) HARNESS ASSEMBLY
9	1	D4728-051	CABIN LIGHT #1 HARNESS ASSEMBLY
10	2	N/A (REF)	SCREW (PART OF D4728-051)
11	2	D4743-1	SPEAKER GRILL
12	8	MS21044-N08	NUT
13	8	MS24693-BB50	SCREW
14	8	NAS1149DN832J	WASHER
15	8	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)
16	1	50-009-2	GROMMET
17	1	2351-20-27-C3C	STUD

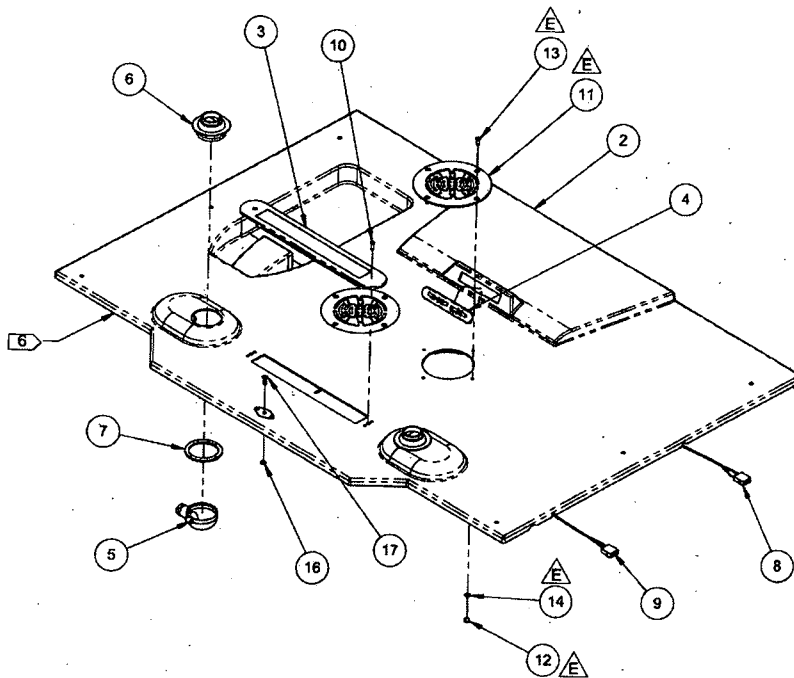
E	REVISED BOM (ZN C4-1, C4-3, D4-5, C4-7, C4-8, C4-9); ADDED NOTE 11) (ZN D5-7, A8-7, D5-8, A8-8, D7-8, A8-9); 3.70 WAS 3.83 (ZN C8-11); 1.88 WAS 2.00 (ZN D7-13); 6.13 WAS 6.25 (ZN B8-16); REVISE DETAIL B (ZN A8-16)	RF	14.01.09
D	ADDED PLT1.5M-M (ZN C4-5, C8-6); D5021-1 (ZN D4-7, D5-7); D5021-3 (ZN D4-8, D5-8); D5021-5 (ZN D4-9, B7-9); MPNY-760S-9-C (ZN D4-9, B7-9); Ø0.129 (ZN B4-11, B4-13); DETAIL "J" (ZN C2-17); 3.83 WAS 3.87 (ZN C8-11); 2.00 WAS 2.02 (ZN D6-15); REVISE NOTE 8) & 10) (ZN A8-7, A8-8, A8-9); & NOTE 1) (ZN A8-10, A8-12, A8-14); 3.80 WAS 3.84 (ZN D4-17, B8-17); REMOVED D4894-7/041/043/045-047, D4847-3/7-9; DIMENSION SHIFTED DUE ADDING D5021-1/1-3/5; Ø0.250 WAS Ø0.208 (ZN D5-11, C3-15 & D6-15)	RF	13.12.09
C	REVISE GENERAL NOTES (ZN A8-7, A8-8, A8-9) & BOM (ZN D4-1, D4-3, D4-5, D4-7, D4-9); Ø0.208 WAS Ø0.207 (ZN D6-11, C3-13, C6-15) ADD DIM. (ZN B8-7, B7-7, D7-8, & D6-8)	RF	13.06.16
B	ADDED D4634-141/143/145 (ZN B4-7, B4-8, B4-9); REVISE D4634-041/042/043/044 PART LIST & GENERAL NOTES; ADD DETAILS R,S,T SHT 10, 12, 14, 16, 17	RF	12.11.30
A	NEW ISSUE	RF	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4634 TITLE CENTER CEILING PANELS COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	RF		
CHECKED	PC		
MFG. APPR.	PC		
APPROVED	PC		
DE APPR.	PC		
DATE	14.01.09		
REV. E	SHEET 1 OF 17	SCALE	NTS



D4634-041 FWD. CENTER CEILING PANEL ASSY
AUXILIARY VIEW

RECEIVED
11 2014 -G- 22

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. E
MFG. APPR.	PC	D4634	SHEET 2 OF 17
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	CENTER CEILING PANELS	NTS
DATE	14.01.09	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4634-041 FWD, CENTER CEILING PANEL ASSY

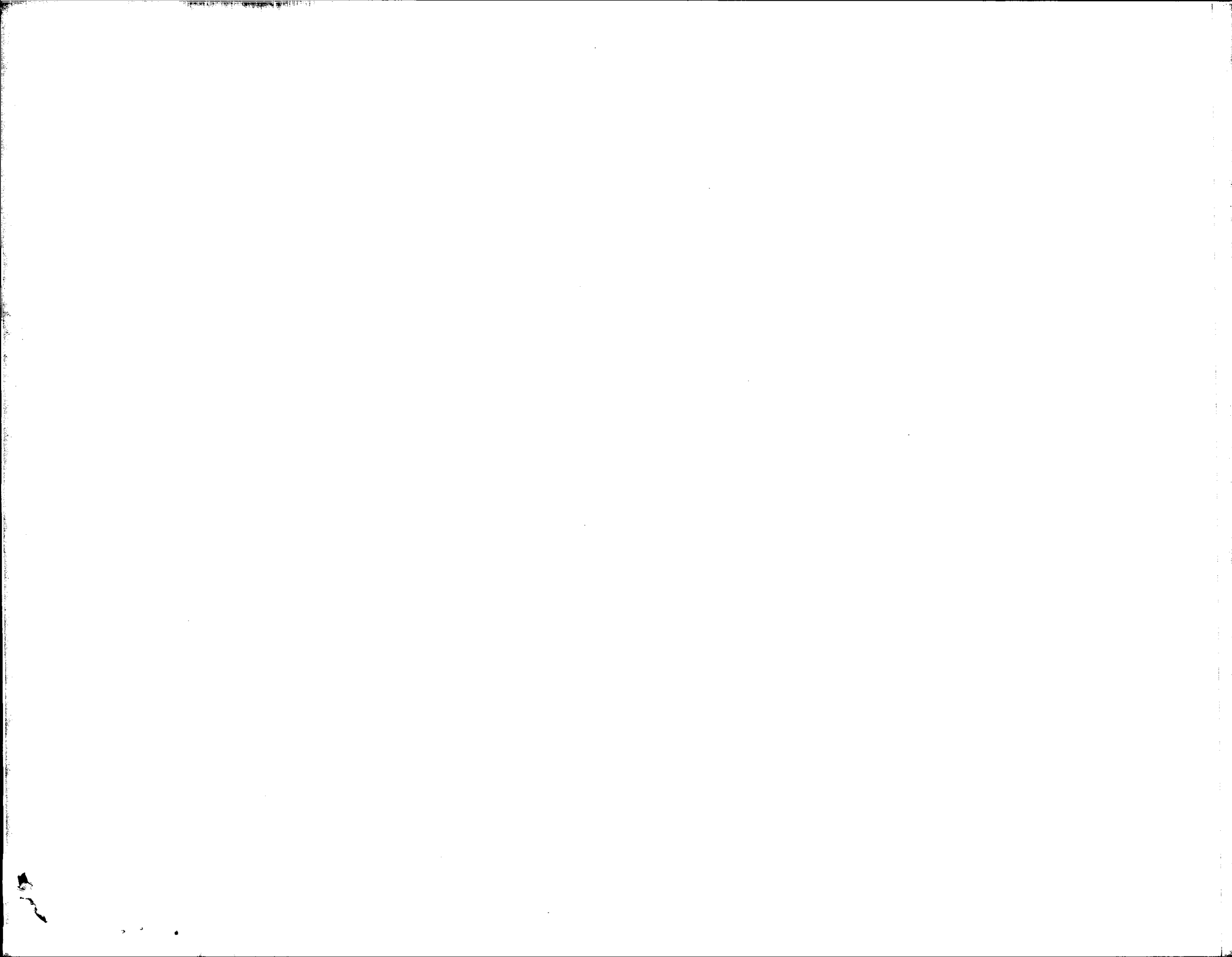
NOTES:

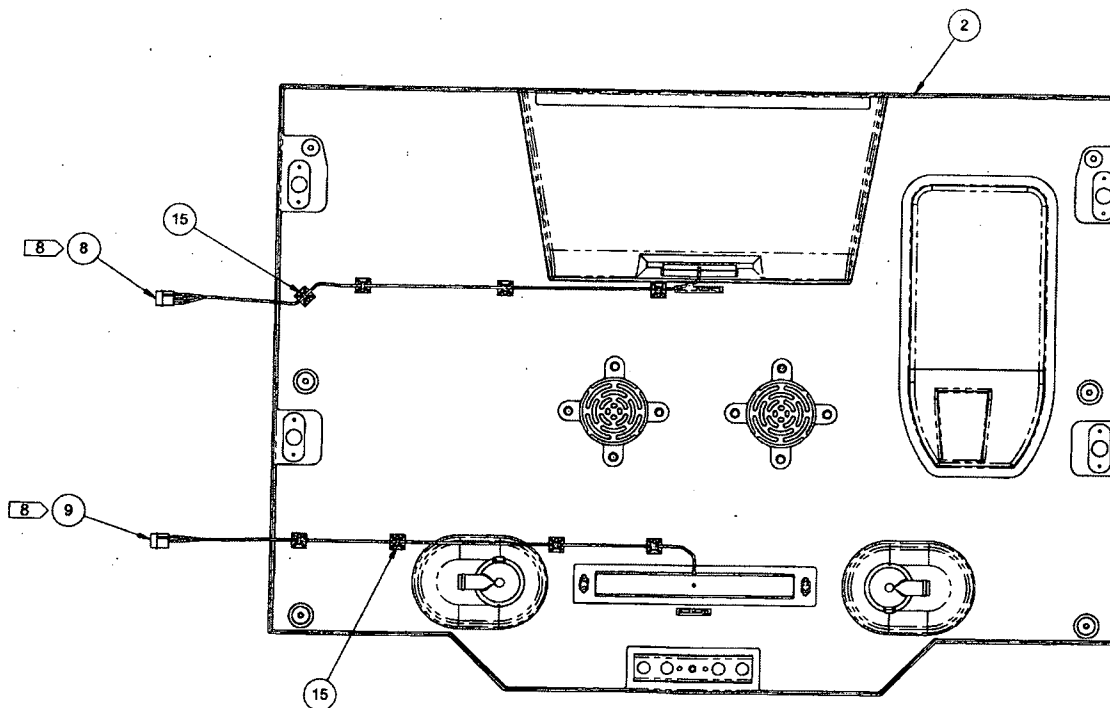
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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4	1	D4645-1 (REF)	NO SMOKING & FASTEN BELT LIGHT (PART OF D4728-047)
5	2	D4646-1	PLENUM CAP ASSEMBLY
6	2	D4652-1	AIR VALVE
7	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-1)
8	1	D4728-047	ADVISORY LIGHT (FWD) HARNESS ASSEMBLY
9	1	D4728-051	CABIN LIGHT #1 HARNESS ASSEMBLY
10	2	N/A (REF)	SCREW (PART OF D4728-051)
11	2	D4743-1	SPEAKER GRILL
12	8	MS21044-N08	NUT
13	8	MS24693-BB50	SCREW
14	8	NAS1149DN832J	WASHER
15	8	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)
16	1	50-009-2	GROMMET
17	1	2351-20-27-C3C	STUD

RECEIVED
14 2014-01-22

E	REVISED BOM (ZN C4-1, C4-3, D4-5, C4-7, C4-8, C4-9); ADDED NOTE 11) (ZN D5-7, A8-7, D5-8, A8-8, D7-9, A8-9); 3.70 WAS 3.83 (ZN C8-11); 1.88 WAS 2.00 (ZN D7-13); 6.13 WAS 6.25 (ZN B6-15); REVISE DETAIL B (ZN A8-18)	RF	14.01.09
D	ADDED PLT1.5M-M (ZN C4-5, C8-6); D5021-1 (ZN D4-7, D5- 7); D5021-3 (ZN D4-6, D5-8); D5021-5 (ZN D4-9, B7-9); MPNY-750S-9-C (ZN D4-8, B7-9); Ø0.129 (ZN B4-11, B4- 13); DETAIL "U" (ZN C2-17); 3.83 WAS 3.67 (ZN C8-11); 2.00 WAS 2.02 (ZN D6-15); REVISE NOTE 8) & 10) (ZN A8-7, A8- 8, A8-9); & NOTE 1) (ZN A8-10, A8-12, A8-14); 5.80 WAS 3.84 (ZN D4-17, B8-17); REMOVED D4694-7/-041/-043/-045/-047, D4647-3/-7/-8; DIMENSION SHIFTED DUE ADDING D5021-1/- 3/-5; Ø0.250 WAS Ø0.208 (ZN D6-11, C3-13 & D6-15)	RF	13.12.09
C	REVISE GENERAL NOTES (ZN A8-7, A8-8, A8-9) & BOM (ZN D4-1, D4-3, D4-5, D4-7, D4-8); Ø0.208 WAS Ø0.207 (ZN D6- 11, C3-13, C8-15) ADD DIM. (ZN B6-7, B7-7, D7-5, & D8-5)	RF	13.06.18
B	ADDED D4634-141/-143/-145 (ZN B4-7, B4-8, B4-9); REVISE D4634-041/-042/-043/-044 PART LIST & GENERAL NOTES; ADD DETAILS R,S,T SHT 10, 12, 14, 16, 17	RF	12.11.30
A	NEW ISSUE	RF	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	PC		
MFG. APPR.	PC		
APPROVED	PC		
DE APPR.	PC		
DATE	14.01.09		
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D4634-041 FWD. CENTER CEILING PANEL ASSY
AUXILIARY VIEW

2014-01-22
JH

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